

Work Order ID 69619

Thursday, May 12, 2011 3:36:24 PM



Page 1

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3296

Rev A

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Fabricate & assemble as per Dwg D3296.

Transfer drill using DT8470 & DT9521

110

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

120

0.00



Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

Powdercoat

Memo

0.00

Powder Coating

START TIME:

2:10

OVEN TEMPERATURE:

FINISH TIME:

3:20

2:40

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69619

Thursday, May 12, 2011 3:36:25 PM



Page 2

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

6 0 BR 11-5-31.

140



Small Fab

Small Fab

Small Fab

Memo

Assemble as per Dwg D3296

0.00

0.00

E 11/06/02 (6)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 11/06/02

(16)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 69619

Thursday, May 12, 2011 3:36:25 PM



Page 3

Item ID: D3296-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Door Assembly

Start Date: 5/12/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 5/24/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 218

0.00



Packaging

Memo

0.00

Packaging

11/6/11 [Signature]

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/11 [Signature]
[Signature]
[Signature]
11-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:36:31 PM

Page 1

Work Order ID: 69619

Parent Item: D3296-041

Parent Item Name: Door Assembly



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP C05.10.14 Added step 14 KJ/EC
IPP Rev:D Revised Steps 06-11-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3161-7 Hinge 14.0"		Manufactured	No			100	Each	6.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST037			6						
					68487		6						
D3161-9 Hinge 17.0"		Manufactured	No			100	Each	8.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST037			8						
					68894		8						
D3296-1 Door Panel		Manufactured	No			100	Each	2.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST186			2						
					66192		2						
D3296-3 Door Panel		Manufactured	No			100	Each	12.0000	1				
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST186			12						
					68482		12						

EP 4/05/30

6
EP 11/05/30

6
EP 11/05/30

2 *370068 (40)*
EP 4/05/30
6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:36:31 PM

Page 2

Work Order ID: 69619

Parent Item: D3296-041

Parent Item Name: Door Assembly

Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

MS20470AD4-6

Purchased

No

100

Each

2,573.000

1



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2573

117395

2573

140

Each

50.0000

1

AN960JD6

NAS1149DN632J

Purchased

No



Washer

47 M116978 (64)

Location

Loc Qty

Loc Code

ST347

50

104537

50

140

Each

11.0000

1

D2137

Manufactured

No



Decal - No Step

Location

Loc Qty

Loc Code

GA

11

62071

5

68923

6

140

Each

1.0000

1

D2419

Manufactured

No



Handle

Location

Loc Qty

Loc Code

GA

1

68896

1

140

f

463.6002

0.3333

1.9998

D2462

Manufactured

No



Seal

Location

Loc Qty

Loc Code

ST404

463.6002

48530

463.6002

6
EBS 11/06/02

6
EBS 11/06/02

6
EBS 11/06/02

6
EBS 11/06/02
B69732 (52)

1.9998
EBS 11/06/02

Thursday, May 12, 2011 3:36:32 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, May 12, 2011 3:36:32 PM

Page 3

Work Order ID: 69619

Parent Item: D3296-041

Parent Item Name: Door Assembly



Start Date: 5/12/2011

Required Date: 5/24/2011

Start Qty: 6.00

Required Qty: 6.00

D2728-1 Manufactured No

140 Each

0.0000

0

0



Dart Logo label

MS20470AD4-4

Purchased No

140 Each

4,070.000

25

150



Rivet, Universal Head

Location

Loc Qty

Loc Code

ST139

1818

117423

1818

ST319

2252

116188

2023

116391

229



EP 5/11/06/02



EP 5/11/05/30

150

Thursday, May 12, 2011 3:36:32 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

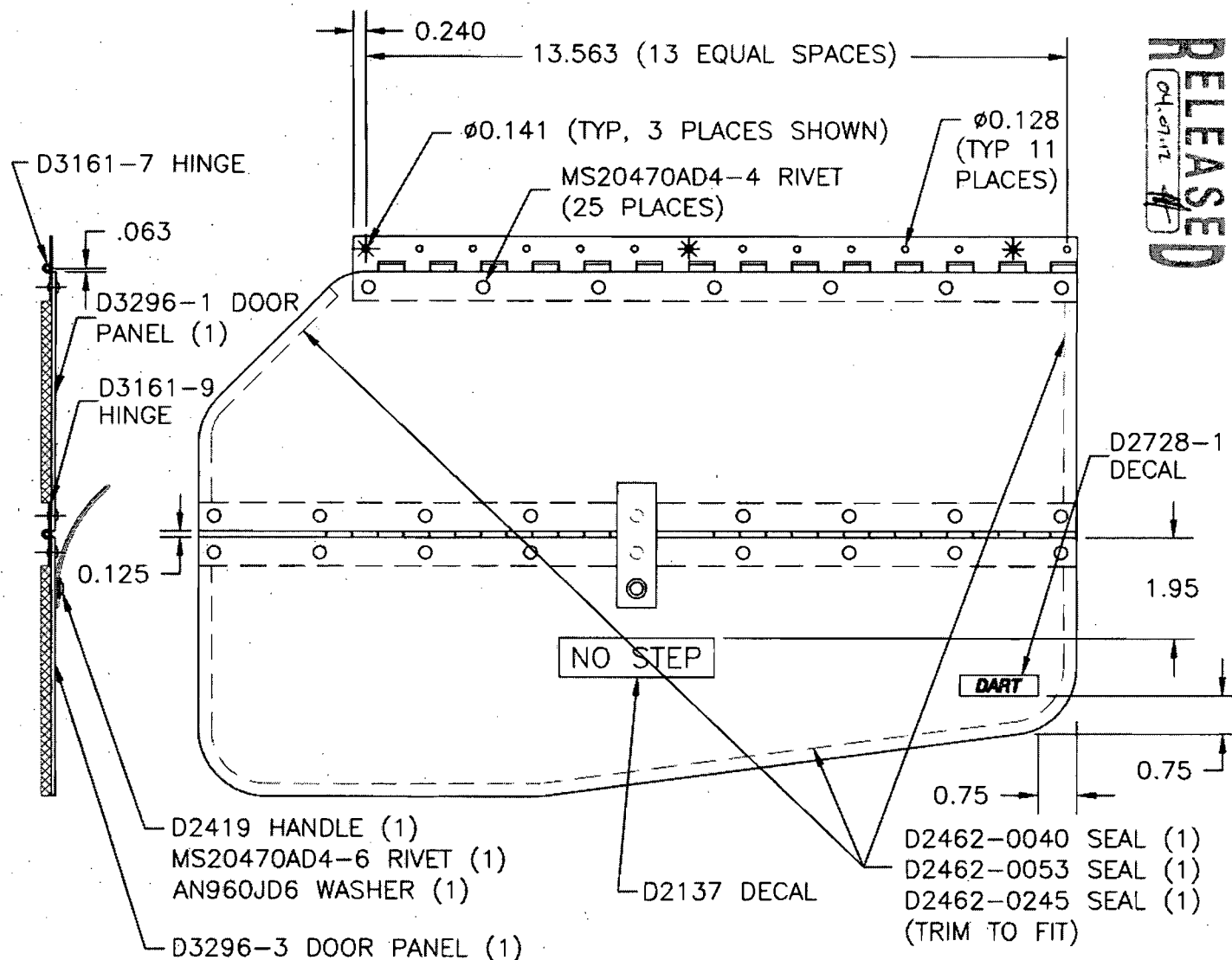
RELEASED
04.07.12

SHW
R
EN
UNCONT
SUBJECT
WITH
WO
NO.



08619
110512

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
04.06.28	04.06.28	D3296
DATE	TITLE	REV. A
04.06.28	DOOR ASSEMBLY	1 OF 2
A	NEW ISSUE	SCALE
		1:3



D3296-041 DOOR ASSEMBLY

- 1) FOLD AND FASTEN D2419 TO FORM 2.5" LONG HANDLE
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) INSTALL D2137 & D2728-1 DECALS, D2419 HANDLE, AND D2462 SEALS AFTER POWDER COAT
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

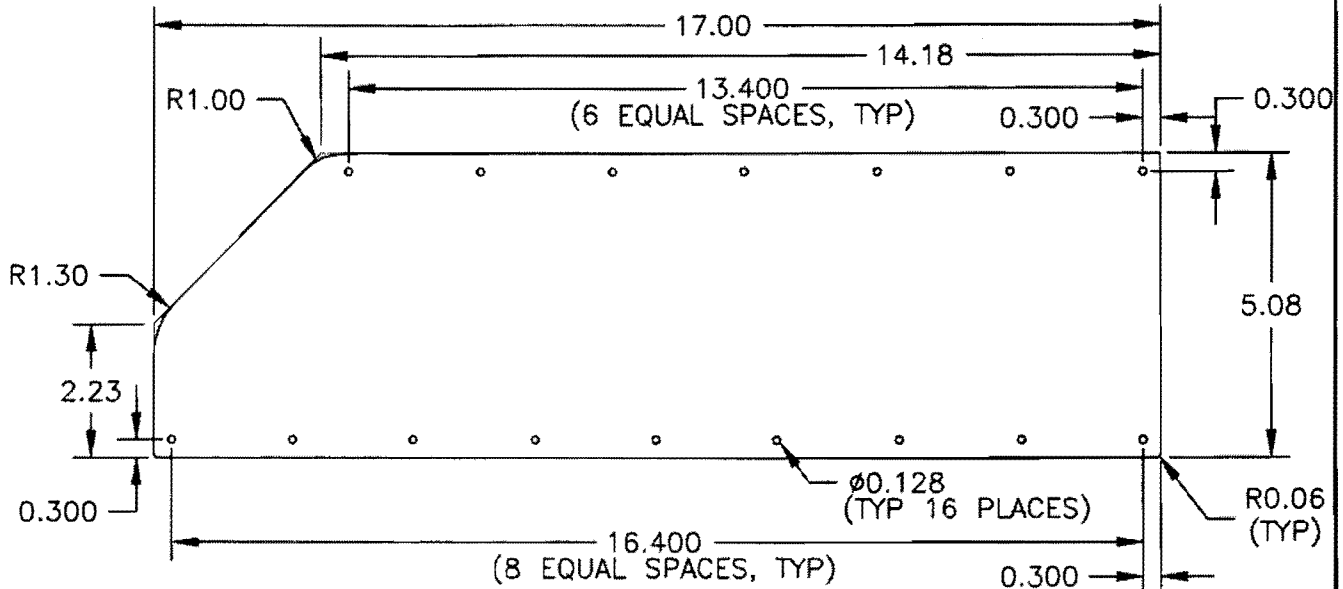
NOTE: Date & initial all entries

46069412

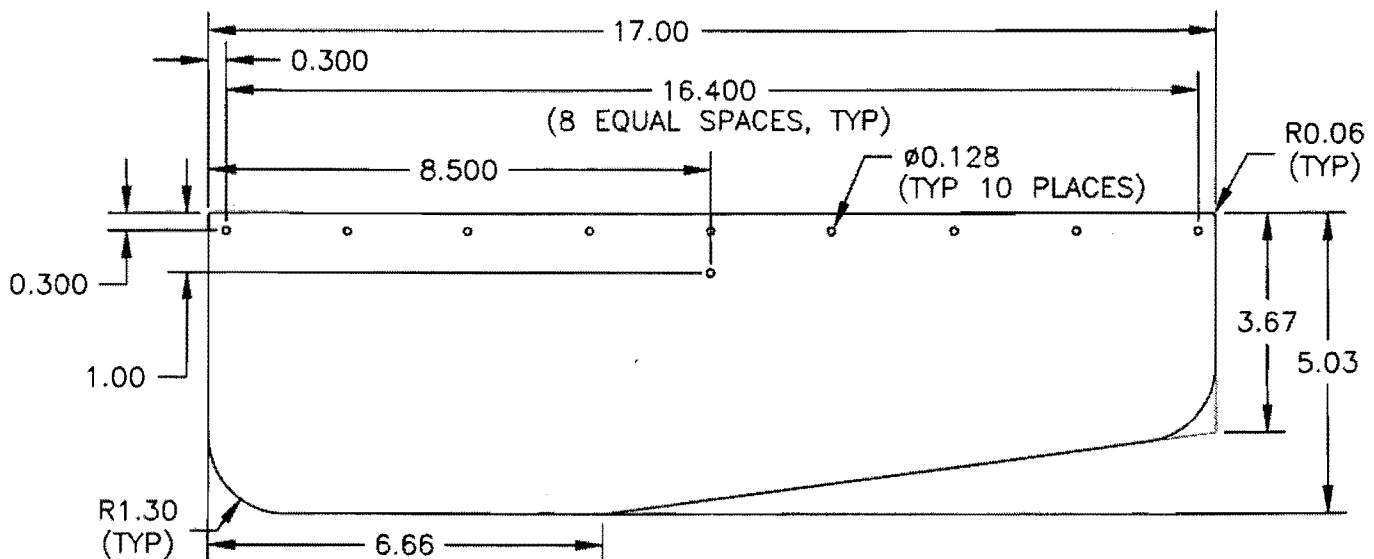
DART



DESIGN UP	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3296	REV. A 2 OF 2
DATE 04.06.28		TITLE DOOR ASSEMBLY	SCALE 1:3



D3296-1 DOOR PANEL



D3296-3 DOOR PANEL

D3296-1 AND D3296-3

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK
(REF DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
04.07.12

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries